

Date: Thursday, 13/11/2008 1:10:35 PM
 User: Julie Dawson

Process Sheet

| | | | | |
|------------------------------------|---|---------------------------|-----------------|-------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | GHW MEDIUM BELL | |
| Job Number : | 43432A | | | |
| Estimate Number : | 12129 | | | |
| P.O. Number : | | Part Number : | D412729041 | |
| This Issue : | 13/11/2008 | S.O. No. : | | |
| Prsht Rev. : | NC | Drawing Number : | DSK 092 REV B | |
| First Issue : | / / | Project Number : | N/A | |
| Previous Run : | 43148A | Drawing Revision : | B | |
| Written By : | | Material : | | |
| Checked & Approved By : | <u>JUD 08.11.14</u> | Due Date : | 10/12/2008 | Qty: 2 Um: Each |
| Comment : | Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

If D412-729-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-729-041 CHG003

N/A

| | | |
|-----|--------|-------|
| 2.0 | D27287 | Label |
|-----|--------|-------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Label 322554

| | | |
|-----|----------|----------------|
| 3.0 | D3233041 | Wheel Assembly |
|-----|----------|----------------|

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-041 Wheel Assembly 343766

P109.01.20

| | | |
|-----|--------|---------------|
| 4.0 | D32331 | Inside Washer |
|-----|--------|---------------|

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-1 Inside Washer 343447

P109.01.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: GHW MEDIUM BELL

Job Number: 43432A

Part Number: D412729041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|----------------|
| 5.0 | D32333 | Outside Washer |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|---------|----------------|--|
| 2 | D3233-3 | Outside Washer | |
|---|---------|----------------|--|

B42465

pl09.01.20

| | | |
|-----|--------|-------|
| 6.0 | D33091 | Label |
|-----|--------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|---------|-------|--|
| 1 | D3309-1 | Label | |
|---|---------|-------|--|

B37078

pl09.01.20

| | | |
|-----|--------|-------|
| 7.0 | D33093 | Label |
|-----|--------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|---------|-------|--|
| 2 | D3309-3 | Label | |
|---|---------|-------|--|

B39445

pl09.01.20

| | | |
|-----|----------|----------------|
| 8.0 | D3330041 | Frame Weldment |
|-----|----------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|-----------|----------------|--|
| 1 | D3330-041 | Frame Weldment | |
|---|-----------|----------------|--|

B43449

pl09.01.20

| | | |
|-----|----------|-----------------|
| 9.0 | D3331041 | Handle Assembly |
|-----|----------|-----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|-----------|-----------------|--|
| 1 | D3331-041 | Handle Assembly | |
|---|-----------|-----------------|--|

B37082

pl09.01.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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|---------|-----------------------|---------------|

| | | |
|------|----------|--------------|
| 10.0 | D3332041 | Pin Assembly |
|------|----------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 D3332-041 Long Pin Assembly B37784

Plog-01-20

| | | |
|------|----------|--------------|
| 11.0 | D3332043 | Pin Assembly |
|------|----------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 D3332-043 Short Pin Assembly B37059

Plog-01-20

| | | |
|------|--------|------------------|
| 12.0 | D33331 | Base Plate Panel |
|------|--------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 D3333-1 Base Plate B43348

Plog 09/01/23

| | | |
|------|--------|---------------|
| 13.0 | D33333 | Sliding Plate |
|------|--------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 D3333-3 Sliding Plate B42472 → 3
B43350 → 1

Plog-01-20

| | | |
|------|--------|------|
| 14.0 | D33335 | Rail |
|------|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
4 D3333-5 Rail B43351 → 7
B43167 → 1

Plog-01-20

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Part Number: D412729041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------|-------------|
| 15.0 | D33341 | Wheel Shaft |
|------|--------|-------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft 34390

lp 09-01-20

| | | |
|------|--------|--------------|
| 16.0 | D33351 | Short Spring |
|------|--------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring 336701

lp 09-01-20

| | | |
|------|--------|-------------|
| 17.0 | D33353 | Long Spring |
|------|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring B43450 → 2x

JS 09/01/23

| | | |
|------|--------|------|
| 18.0 | D33361 | Jack |
|------|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack 343352

lp 09-01-20

| | | |
|------|------------|--------|
| 19.0 | AN960JD416 | Washer |
|------|------------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer M109249

lp 09-01-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | |
|------|------|-------------------------|
| 20.0 | CP21 | 1/8" Cotter Pin 2" long |
|------|------|-------------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:



Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span M108200

Pl09.01.20

| | | |
|------|------|--------------------------|
| 21.0 | HC12 | 1/4-20 UNC x 1" Hex Bolt |
|------|------|--------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span M16529

Pl09.01.20

| | | |
|------|------|--------------------------|
| 22.0 | HC29 | 5/16-18 UNCx1.5 Hex Bolt |
|------|------|--------------------------|



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof M109923

Pl09.01.20

| | | |
|------|-------|--------------------------|
| 23.0 | HC153 | 3/8"-24UNFx1.25 Hex Bolt |
|------|-------|--------------------------|



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span M109654 → 1

M110084 → 15

Pl09.01.20

| | | |
|------|-------|-----------------|
| 24.0 | HN120 | HEX SLOTTED NUT |
|------|-------|-----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-1201" Slotted Nut, Prof M102150

Pl09.01.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: GHW MEDIUM BELL

Job Number: 43432A

Part Number: D412729041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-------|--------------------------|
| 25.0 | HN177 | 5/16-18UNC Nylon LockNut |
|------|-------|--------------------------|



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span

M108200 → 20
M110284 → 12

Pl09-01-20

| | | |
|------|------|-------------------------|
| 26.0 | HX15 | 1/4-20 UNCx3/4 S.H.C.S. |
|------|------|-------------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span

M108200

Pl09-01-20

| | | |
|------|-----------|-----|
| 27.0 | MS21042L5 | Nut |
|------|-----------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

M109297

Pl09-01-20

| | | |
|------|------|----------------------|
| 28.0 | 2333 | 1 1/4" Type B Washer |
|------|------|----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span

M102150

Pl09-01-20

| | | |
|------|-------|------------------|
| 29.0 | 18SNB | 3/8" Lock Washer |
|------|-------|------------------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span

M107031 → 6
M110611 → 10

Pl09-01-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 43432A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span

M1106512

Cpl 09-01-20

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof

B M109326 → 2x

M110138 → 30x

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

SH 09/01/23

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

68-01-23 (2)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 43432

PU 09/01/23 (2)

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

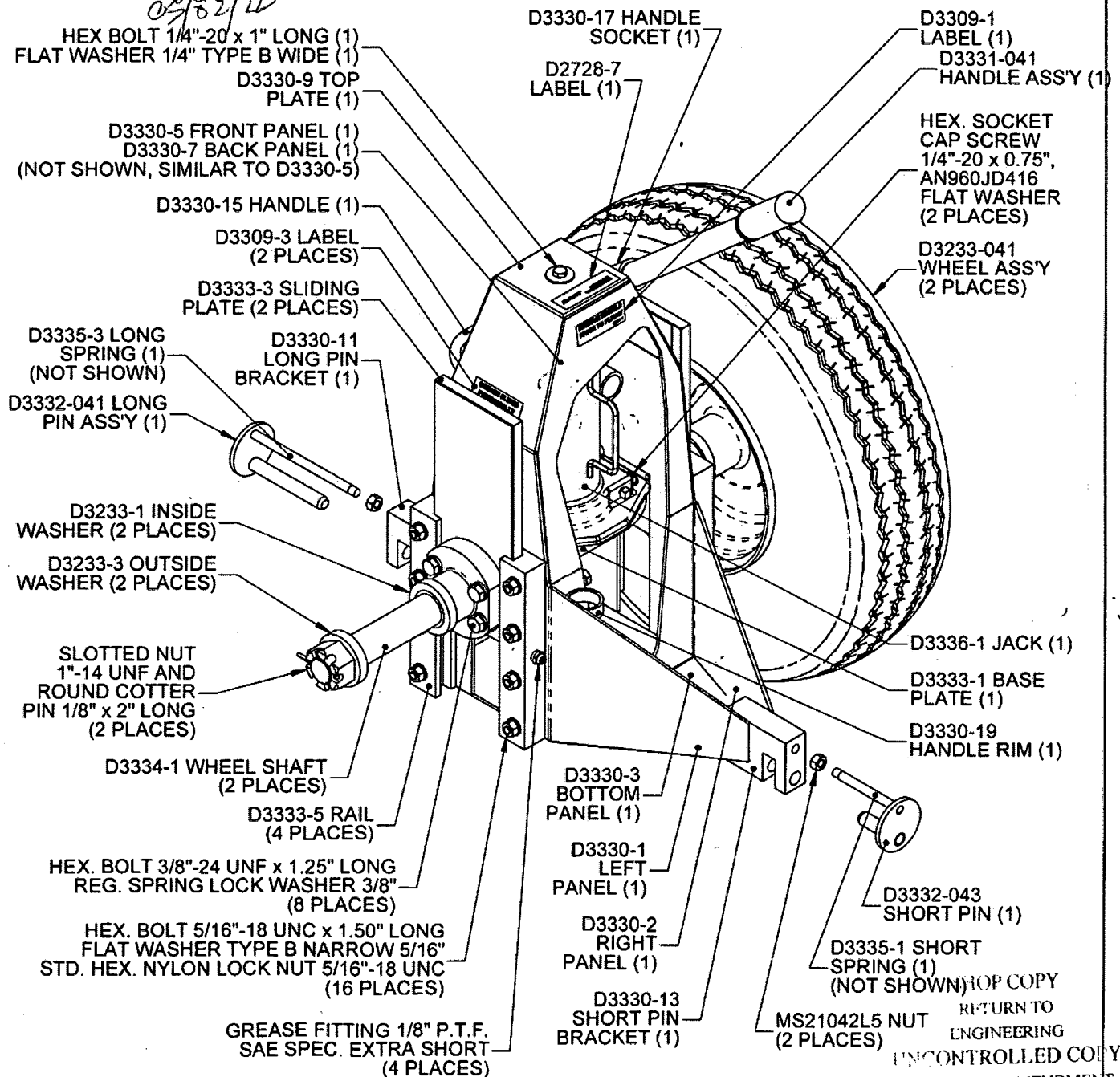
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DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. DSK 092 | REV. B SHEET 1 OF 1 |
| DATE 05.02.18 | | TITLE HYD. GROUND HANDLING | SCALE 1:5 |
| A | 04.12.06 | NEW ISSUE | |
| B | 05.02.18 | REDESIGN TO FIT NEW WHEEL ASS'Y | |

RELEASED
[Signature]
05/02/18**NOTE:**

1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

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